Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

split 5231678

D2360

Job Sheet 202278-A

Part No: D2360 **Job Qty:** 5 pcs
Part Name: Litter Tie Down Bracket

Part Weight: 0 lbs **Status:** Scheduled **Priority:** Medium
Job Created: 11/14/19 **Job Tracking No:**
Due Date: 11/18/19 **Created By:** Linda Lacelle
Type: SOLD **Description:**
Note: DWG D2341 REV G, D2360 REV D IPP rev H 07.06.12 ecn 825 EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier	Workcenter / Supplier Lead Time	Sign-off
160	QC 3	5 pcs		11/18/19	0.00	0.00	QC 3 - 10		
							QC 3 - 13		
							QC 3 - 15		
							QC 3 - 17		
							QC 3 - 18		
							QC 3 - 2		
							QC 3 - 28		
							QC 3 - 3		
							QC 3 - 30		
							QC 3 - 34		
							QC 3 - 36		
							QC 3 - 41		
							QC 3 - 51		
							QC 3 - 58		
							QC 3 - 59		
							QC 3 - 68		
							QC 3 - 9		
							QC 3 - 40		
							QC 3 - 19		
							QC 3 - 43		
							QC 3 - 24		
							QC 3 - 61		
							QC 3 - 81		
170	Small Fab - 2 - B4B	5 pcs		11/18/19	0.00	1.57	Small Fab - 1 - B4B		DAS
							Small Fab - 2 - B4B		58 JAN 0 3 2020
							Small Fab - 3 - B4B		9-89
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		

180 **QC 5**	5 pcs	11/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	DAS 40 3-89
				QC 5 - 40	JAN 0 6 2020
				QC 5 - 61	
				QC 5 - 81	
190 **Packaging 3-1 - Stock - B4B**	5 pcs	11/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	DAS
				Packaging 3 - 23 - B4B	34 St. 225
				Packaging 3 - 24 - B4B	9-89
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 **QC 21 - SA**	5 pcs	11/18/19	0.00 0.00	QC 21 - SA - 21	DAS 21 5-89
				QC 21 - SA - 70	JAN 0 7 2020
				QC 21 - SA - 53	

Part Op **160** - (QC3- Inspect Part Finish)

Descriptions: **170** - (Small Fab) Assemble as per dwg D2360
180 - (QC5- Inspect part completeness to step on W/O)
190 - (Identify as per dwg & Stock Location:_____)
200 - (QC21- Final Inspection - Work Order Release)

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN526C1032R18	Screw	5 Ea (1 ea)	170-Small Fab - 2 - B4B	S231107
D2002-015	Knob	10 pcs (2 ea)	170-Small Fab - 2 - B4B	S194795
D2345	Lock Channel	5 pcs (1 ea)	170-Small Fab - 2 - B4B	S229120
D2366	Lock Handle	10 pcs (2 ea)	170-Small Fab - 2 - B4B	S231199
D2367	Handle Knob	5 pcs (1 ea)	170-Small Fab - 2 - B4B	S231200
D2372	Quick Release	10 pcs (2 ea)	170-Small Fab - 2 - B4B	S231774
D2373	Spring	5 pcs (1 ea)	170-Small Fab - 2 - B4B	S161152X1 S194037X2 S244495
D2444	Pip Pin Assembly	5 pcs (1 ea)	170-Small Fab - 2 - B4B	S244097
MS20470AD3-4	Rivet, Universal Head	5 Ea (1 ea)	170-Small Fab - 2 - B4B	S231201
MS21042L3	Nut	15 Ea (3 ea)	170-Small Fab - 2 - B4B	S231202
MS27039-1-13	Screw	5 Ea (1 ea)	170-Small Fab - 2 - B4B	S231203
MS27039-1-15	Screw	10 Ea (2 ea)	170-Small Fab - 2 - B4B	S231204
NAS1149D0332J	Washer	40 Ea (8 ea)	170-Small Fab - 2 - B4B	S231205
NAS1149D0363J	Washer	10 Ea (2 ea)	170-Small Fab - 2 - B4B	S231206
NAS679A3W	Nut	5 Ea (1 ea)	170-Small Fab - 2 - B4B	S131215

CA128
CA127

X2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
170-Small Fab - 2 - B4B	AN526C1032R18	5	38	0
	D2002-015	10	53	0
	D2345	5	35	0
	D2366	10	41	0
	D2367	5	36	0
	D2372	10	30	0
	D2373	5	14	0
	D2444	5	12	0
	MS20470AD3-4	5	4,987	0
	MS21042L3	15	2,396	0
	MS27039-1-13	5	276	0
	MS27039-1-15	10	173	0
	NAS1149D0332J	40	3,496	0
	NAS1149D0363J	10	1,190	0
	NAS679A3W	5	204	0

Part Specifications

Specifications could not be found.

Plex 11/14/19 8:59 AM dart.lacelle.linda

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2360
Job Sheet 202278

Part No: D2360 **Job Qty:** ~~5~~ pcs 10
Part Name: Litter Tie Down Bracket

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 10/23/19 **Job Tracking No:**
Due Date: 11/18/19 **Created By:** Marie Lajeunesse
Type: SOLD **Description:**
Note: DWG D2341 REV G, D2360 REV D IPP rev H 07.06.12 ecn 825 EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Bandsaw - 1	15 pcs		11/18/19	0.00	0.50	Bandsaw - 1		
110	HAAS 4 Axis - B4B	15 pcs		11/18/19	0.26	22.39	HAAS - 1 - B4B		DP 14-11-07
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	15 pcs		11/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51	DAS	
							QC 2 - 52	52	19/11/06
							QC 2 - 57	9 89	
							QC 2 - 62		

DART AEROSPACE
Container No: S229551
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632 – 5200
Email: sales@dartaero.com
www.dartaerospace.com
Part: D2360
Job No: 202278
Serial No/Batch: S229551
Revision:
Inspector:
Exp Date:
Instructions: Various STC's
Date: 11/06/19

					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	DJP 19-11-07
					QC 2 - 69	
130 **QC 8**	15 pcs	11/18/19	0.00	0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	[illegible] 19/11/08
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140 **Handfinish - 1-1 Chemical-B4B**	15 pcs	11/18/19	0.00	1.17	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	NOV 12 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 -	

					B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	**Powdercoat - 1 White GI(A)-B4B**	15 pcs	11/18/19	0.00 0.75	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	**QC 3**	15 pcs	11/18/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170	**Small Fab - 2 - B4B**	15 pcs	11/18/19	0.00 4.72	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
180	**QC 5**	15 pcs	11/18/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	

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START: 11:20 OUT: 300° FINISH: 11:50.

BL 19 11-12.

					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190	**Packaging 3-1 - Stock - B4B**	15 pcs	11/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	

					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
200	QC 21 - SA	15 pcs	11/18/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op Descriptions:
100 - (Bandsaw) Cut blanks: 12.65" Long
110 - (HAAS CNC vertical machine #1) 1-Machine as per Folio D2341 and Dwg D2341 **2-Deburr**
120 - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
160 - (QC3- Inspect Part Finish)
170 - (Small Fab) Assemble as per dwg D2360
180 - (QC5- Inspect part completeness to step on W/O)
190 - (Identify as per dwg & Stock Location:_____)
200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	15.8100 ft (1.054 ea)	100-Bandsaw - 1	
AN526C1032R18	Screw	15 Ea (1 ea)	170-Small Fab - 2 - B4B	
D2002-015	Knob	30 pcs (2 ea)	170-Small Fab - 2 - B4B	
D2345	Lock Channel	15 pcs (1 ea)	170-Small Fab - 2 - B4B	
D2366	Lock Handle	30 pcs (2 ea)	170-Small Fab - 2 - B4B	
D2367	Handle Knob	15 pcs (1 ea)	170-Small Fab - 2 - B4B	
D2372	Quick Release	30 pcs (2 ea)	170-Small Fab - 2 - B4B	
D2373	Spring	15 pcs (1 ea)	170-Small Fab - 2 - B4B	
D2444	Pip Pin Assembly	15 pcs (1 ea)	170-Small Fab - 2 - B4B	
MS20470AD3-4	Rivet, Universal Head	15 Ea (1 ea)	170-Small Fab - 2 - B4B	
MS21042L3	Nut	45 Ea (3 ea)	170-Small Fab - 2 - B4B	
MS27039-1-13	Screw	15 Ea (1 ea)	170-Small Fab - 2 - B4B	
MS27039-1-15	Screw	30 Ea (2 ea)	170-Small Fab - 2 - B4B	
NAS1149D0332J	Washer	120 Ea (8 ea)	170-Small Fab - 2 - B4B	
NAS1149D0363J	Washer	30 Ea (2 ea)	170-Small Fab - 2 - B4B	
NAS679A3W	Nut	15 Ea (1 ea)	170-Small Fab - 2 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	D6201	16	17	0
170-Small Fab - 2 - B4B	AN526C1032R18	15	38	0
	D2002-015	30	29	0
	D2345	15	5	0
	D2366	30	13	0
	D2367	15	36	0
	D2372	30	16	0
	D2373	15	14	0
	D2444	15	3	0
	MS20470AD3-4	15	5,131	0
	MS21042L3	45	2,767	0
	MS27039-1-13	15	286	0
	MS27039-1-15	30	183	0
	NAS1149D0332J	120	1,498	0
	NAS1149D0363J	30	887	0
	NAS679A3W	15	6	0

Part Specifications
Specifications could not be found.

Plex 10/23/19 1:34 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	202278
Description: Litter Tie Down Bracket (Locking)		Part Number:	D2341
Inspection Dwg: D2341 **Rev:** G			Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.751	V		Ver	
2.75	+/-0.030	2.75	V		Ver	
Ø0.246	+0.005/-0.001	Ø.0246	V		G.P	
Ø0.191	+0.005/-0.001	Ø.0191	V		G.P	
R0.25	+/-0.030	R0.25	V		R.G.	
R0.40	+/-0.030	R0.40	V		R.G.	
12.50	+/-0.030	12.50	V		H.G.	
11.750	+/-0.010	11.750	V		H.G.	
11.00	+/-0.030	11.00	V		H.G.	
7.00	+/-0.030	7.00	V		Ver	
6.250	+/-0.010	6.248	V		Ver	
5.50	+/-0.030	5.50	V		Ver	
1.50	+/-0.030	1.499	V		Ver	
0.750	+/-0.010	0.749	V		Ver	
0.400	+/-0.010	0.400	V		H.G.	
1.584	+/-0.010	1.580	V		H.G.	
2.610	+/-0.010	2.606	V		H.G.	
0.250	+/-0.010	0.250	V		H.G.	
0.844	+/-0.010	0.844	V		Ver	
Ø0.250	+/-0.010	Ø0.250	V		Ver	
0.750	+/-0.010	0.750	V		Ver	
3.313	+/-0.010	3.311	V		H.G.	
4.250	+/-0.010	4.250	V		H.G.	
1.250	+/-0.010	1.246	V		H.G.	
	DAS					

Measured by:	52 9-89	**Checked by:**		**QC Inspector:**	
Date:	19/11/24	**Date:**	19/11/24	**Date:**	

Engineering Approval: (If necessary)		**Date:**	

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	
D	16.06.14	Dimensions updated per Dwg Rev G	KJ	

Entered: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only ☐

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐
Quality ☐

Date :	Sequence #:	QTY Affected :	MRB (QSI042)

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong
☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance
☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing
☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish
☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing
☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread
☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up

Other/Details: